



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D2893-1
Job Sheet 193118



Part No: D2893-1

Job Qty: 12 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 4/26/19

Description:

Type: SOLD

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	4/26/19	4/26/19	0.33	23.53	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		KT 19-04-21
120	QC 8	12 pcs	4/26/19	4/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		mmL 19/04/21
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							Crosstubes - 1 - B4B		RD 19-4-24
							Crosstubes - 2 - B4B		
130	Crosstubes - 2 - B4B	12 pcs	4/26/19	4/26/19	0.00	2.00			



Container No: S173692



Part: D2893 - 1

Job No: 193118

Serial No/Batch: S173692

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/21/19

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

				Crosstubes - 3 - B4B	
				Crosstubes - 4 - B4B	
140	QC 3	12 pcs	4/26/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
170	Packaging 3-1 - Stock - B4B	12 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
180	QC 21 - SA	12 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

DAS
APR 25 2019 40
9-89

LG050 APR 26 2019

DAS
21 APR 26 2019
9-89

Part Op **100** - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081Descriptions: **120** - (QC8- Inspect parts - second check)**130** - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. *5133992 exp 11/20***140** - (QC3- Inspect Part Finish)**170** - (Identify as per dwg & Stock Location: _____) LOCATION : LG050**180** - (QC21- Final Inspection - Work Order Release)**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	6 pcs (.5 ea)	100-HAAS 4 Axis	<i>5170125</i> <i>62</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	6	14	0

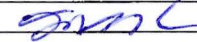
Part Specifications

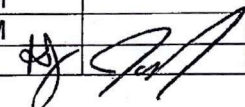
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

DART AEROSPACE LTD		Work Order: 193119
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.998	2.998	2.995	3.000
AB	0.440	0.460		0.450	0.450	0.450	0.450	0.450
AC	0.125	0.160		0.160	0.160	0.160	0.160	0.160
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AF	0.125	0.160		0.138	0.138	0.138	0.138	0.138
AG	0.140	0.160		0.147	0.146	0.146	0.150	0.150
AH	1.360	1.400		1.374	1.371	1.372	1.370	1.370
AI	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AJ	1.190	1.230		1.211	1.206	1.207	1.207	1.207
AK	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AL	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.525	2.525	2.525	2.525	2.525
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.0625	0.0625	0.0625	0.0625	0.0625
AR								
AS								
AT								
Accept/Reject								

Measured by: 	Date: 19-04-17
Audited by: 	Date: 19/04/17
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	193110
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	* 6	* 7	* 8	* 9	* 10
HAAS Section								
AA	2.985	3.005		2.998	2.998	2.995	2.998	2.995
AB	0.440	0.460		0.450	0.450	0.450	0.450	0.450
AC	0.125	0.160		0.160	0.160	0.160	0.160	0.160
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AF	0.125	0.160		0.138	0.138	0.138	0.138	0.138
AG	0.140	0.160		0.156	0.149	0.148	0.149	0.148
AH	1.360	1.400		1.372	1.372	1.369	1.372	1.369
AI	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AJ	1.190	1.230		1.207	1.209	1.207	1.209	1.207
AK	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AL	0.053	0.073		0.0625	0.0625	0.0625	0.0625	0.0625
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.525	2.525	2.525	2.525	2.525
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.0625	0.0625	0.0625	0.0625	0.0625
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>KT</i>	DAS 1 9-89	Date: 19-04-21
Audited by:		Date: 19/04/22
Preliminary Approval:	<i>mark</i>	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	193116
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.998	2.995			
AB	0.440	0.460		0.450	0.450			
AC	0.125	0.160		0.160	0.160			
AD	0.040	0.060		0.050	0.050			
AE	0.188	0.193		0.188	0.188			
AF	0.125	0.160		0.138	0.138			
AG	0.140	0.160		0.150	0.150			
AH	1.360	1.400		1.372	1.369			
AI	0.040	0.060		0.050	0.050			
AJ	1.190	1.230		1.209	1.207			
AK	0.010	0.020		0.010	0.010			
AL	0.053	0.073		0.0625	0.0625			
AM	0.240	0.260		0.250	0.250			
AN	2.518	2.538		2.525	2.525			
AO	84.39	90.39		87.39	87.39			
AP	0.261	0.266		0.261	0.261			
AQ	0.053	0.073		0.0625	0.0625			
AR								
AS								
AT								
Accept/Reject								

Measured by:	DAS 1	Date:	19/04/01
Audited by:	9-89 [Signature]	Date:	19/04/22
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	[Signature]